

# Work Order ID 85607

**\*85607\***

Page 1

June-12-12 8:48:40 AM

Item ID: D2571

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle, Fwd Out 205

Stop

**\*NS2\***

Start Date: 12/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2571	Rev E								
100		0.00							
<b>*100*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1		0.00							
HAAS CNC vertical machine #1	Memo								
	Program Batch No. <u>85607</u> Double check by: _____ 1-Machine Step No 1								
	per Folio FA051 and inspect per attached Dimension Sheets2-Machine Step								
	No 2 per Folio FA051 and inspect per attached Dimension Sheets3-Machine								
	Step No 3 per Folio FA051 and inspect								
110		0.00							
<b>*110*</b>	CONVENTIONAL MILLING MACHINE								
Mill Conv		0.00							
Conventional Milling Machine	Memo								
	Machine keyway as per dwg D2571 & D2572								
120		0.00							
<b>*120*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								

24 12-6-27 8 0

PO 12/06-30

SL

24 12-7-6 8 1

8 1

PO 12/06/30

SL

W/O: 85607		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: ☒ Yes No DQA: OK Date: 12/07/17  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: OK Date: 12/7/18

NCR: 12-1585		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-16-28	100	- 1 saddle dimensions ① and ② are off by .063, the origin in machine was off by .061 x1 RC origin not set correctly operator error.	WJ 12/07/13	SCRAP replace Batch 85432 P 12/7/13	SL 12/07/13	OK 12/07/13	WJ 12/07/13	S 12/07/13

NOTE: Date & initial all entries

# Work Order ID 85607

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**\*85607\***

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Item ID: D2571

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle, Fwd Out 205

Stop

**\*NS2\***

Start Date: 12/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*mt 12/07/08*

*8*

*8*

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

*8*

*mt 12-79*

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*3200F*

*1530*

*8X*

*mt*

*12/07/09*

*mt 12/84/*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85607

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**\*85607\***

Page 3

Item ID: D2571

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, Fwd Out 205

Start Date: 12/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>432</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

8 6 12/7/9

8 12-7-10

OK 12/7/11

mk  
-12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-12-12 8:48:43 AM

Page 1

Work Order ID: 85607

**\*85607\***

Parent Item: D2571

**\*D2571\***

Parent Item Name: Saddle, Fwd Out 205

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated  
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	17.0000	1	8			
<b>*D6101-007*</b>									<b>**</b>				
Saddle Billet													

*27-6*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT041	16	
83450	16	
MAT042	1	
79875	1	

*85432*

*8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25607
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.010	8.001	8.002	8.002		
F	0.490	0.510		.501	.497	.501	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.504	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.572	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.124	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.125	.126	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.242	.241	.242		
W	0.115	0.135		.120	.119	.120	.120		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.248	.248		
AE	1.375	1.395		1.388	1.389	1.390	1.390		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.249	.249	.249		
AI	2.000	2.020		2.003	2.002	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	12-06-28

Audited by:	CM
Date:	12/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	85607
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.439	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.003	8.003	8.003		
F	0.490	0.510		.497	0.502	0.497	0.504		
G	0.257	0.262		.258	.258	.258	0.258		
H	0.375	0.380		.377	.377	.377	0.377		
I	0.490	0.510		.501	.500	.501	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.177		
K	0.558	0.578		.568	.568	.567	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.125	.125	0.125		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.251	.251	.250	0.250		
S	0.115	0.135		.127	.126	.125	0.123		
T	0.178	0.198		.188	.188	.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.243	.241	0.243		
W	0.115	0.135		.120	.120	.118	0.118		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	0.365	0.364	0.364		
AA	0.470	0.530		.500	.500	.500	0.500		
AB	0.615	0.635		.626	.626	0.630	0.630		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.248	.247	0.249		
AE	1.375	1.395		1.389	1.389	1.391	1.390		
AF	0.115	0.135		.130	.130	.130	0.130		
AG	0.240	0.280		.260	.260	.260	0.260		
AH	0.240	0.260		.249	.248	.248	0.247		
AI	2.000	2.020		2.004	2.004	2.006	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	J/P
Date:	12-06-29

Audited by:	and
Date:	12/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries